



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.4211

Job Sheet 197810



Part No: 647.4211

Job Qty: 10 pcs

Part Name: Bracket RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/17/19

Job Tracking No:

Due Date: 8/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C IPP REV A RQ 14/05/28 VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run	Workcenter / Supplier Lead Time	
					Hrs	Hrs		
100	Bandsaw - 1	10 pcs		8/20/19	0.00	1.03	Bandsaw - 1	DJP 9-08-07 DJP 9-08-07
110	HAAS 4 Axis - B4B	10 pcs		8/20/19	1.00	1.03	HAAS - 1 - B4B	
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
120	QC 2	10 pcs		8/20/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	



Container No: S203321



Part: 647.4211

Job No: 197810

Serial No/Batch: S203321

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/07/19

Plex 7/17/19 7:49 AM Dart.lajeunesse.marie

130 QC 8	10 pcs	8/20/19	0.00 0.00	QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	DIP 19-08-01
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
QC 8 - 39					
QC 8 - 4					
QC 8 - 44					
QC 8 - 45					
QC 8 - 49	man 19/08/07				
QC 8 - 58					
QC 8 - 8					
QC 8 - 9					
QC 8 - 68					
QC 8 - 67					
QC 8 - 1 (A)					
QC 8 - 47					
QC 8 - 40					
QC 8 - 52					
QC 8 - 23					
QC 8 - 57					
140 Outsource - 4 - Anodize	10 pcs	8/20/19	0.00 0.00	ATG 001	2019-08-14
150 Packaging 2-1 - Recelve - B4B	10 pcs AC	8/20/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	AC AUG 28 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	

				Packaging 2 - 26 - B4B					
				Packaging 2 - 27 - B4B					
				Packaging 2 - 28 - B4B					
				Packaging 2 - 29 - B4B					
				Packaging 2 - 30 - B4B					
				Packaging 2 - 31 - B4B					
				Packaging 2 - 32 - B4B					
				Packaging 2 - 33 - B4B					
				Packaging 2 - 34 - B4B					
				Packaging 2 - 35 - B4B					
				Packaging 2 - 36 - B4B					
				155 QC 5 <i>X6</i>	10 pcs	8/20/19	0.00 0.00	QC 5 - 10	
								QC 5 - 12	
QC 5 - 17									
QC 5 - 18									
QC 5 - 19									
QC 5 - 22									
QC 5 - 24									
QC 5 - 3									
QC 5 - 43									
QC 5 - 49									
QC 5 - 51									
QC 5 - 58									
QC 5 - 68									
QC 5 - 9									
QC 5 - 50									
QC 5 - 30									
QC 5 - 40									
QC 5 - 61									
QC 5 - 81									
180 Packaging 3-1 - Stock - B4B	10 pcs	8/20/19	0.00 0.00	Packaging 3 - 1 - B4B					
				Packaging 3 - 2 - B4B					
				Packaging 3 - 3 - B4B					
				Packaging 3 - 4 - B4B					
				Packaging 3 - 5 - B4B					
				Packaging 3 - 6 - B4B					
				Packaging 3 - 7 - B4B					
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				Packaging 3 - 10 - B4B					
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				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					

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SEP 03 2019

PC *CK112*

					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	10 pcs	8/20/19	0.00 0.00	QC 21 - SA - 21	DAS	
				QC 21 - SA - 70	21	
				QC 21 - SA - 53	9-89	SEP 03 2019

Part Op 100 - (Bandsaw) Cut Blanks at 9.10"

Descriptions: 110 - HAAS1-1 (HAAS CNC Vertical Machine) 1-Machine per folio FB305

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 44264

150 - (Receive & Inspect for Damage & Mat'l Certs) Mat'l Certs req'd.

155 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location:) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6A1.250X1.00X0.100X0.125	7075T6 Angle 1.25" X 1.00" X .100W" X .125R	7.5800 ft (.758 ea)	100-Bandsaw -	M136944

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6A1.250X1.00X0.100X0.125	8	22	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket, RH	8.900inches ± 0.010	8.910 8.890	8.902	
2	Bracket, RH	0.250inches ± 0.010	0.260 0.240	0.255	
3	Bracket, RH	17.100Degrees ± 0.500	17.600 16.600	17.100°	Angle
4	Bracket, RH	3.250inches ± 0.010	3.260 3.240	3.255	
5	Bracket, RH	1.600inches ± 0.010	1.610 1.590	1.600	
6	Bracket, RH	121.300Degrees ± 0.500	121.800 120.800	121.300°	
7	Bracket, RH	0.375inches ± 0.005	0.380 0.370	0.375	Radius
8	Bracket, RH	0.689inches ± 0.005	0.694 0.684	0.689	

19-08-06

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9-89

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Mat used → 8,000 ft.

BOM → -7.580 ft.

Scrap → 0.420 ft.



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐																															
Date :	Sequence #:	QTY Affected :		MRB (QS1042)																															
Description Work Order Deviation		Disposition		Completed By																															
				Lead hand / Supervisor																															
				QC / QA Coordinator																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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		Other/Details:																																	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044264



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044264

PO Date: 8/14/19

Due Date: 8/20/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pyrm Terms: Net 30

Freight Terms:

Special Comments:

2019-08-16
DATE

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197810	647.4211	Bracket RH : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed	-	8/20/19	10 pcs	0 pcs	10 pcs	\$14.15/pcs	\$141.50
2	198877	647.4210	Bracket LH : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 1- Black Anodize as per Dwg 647.4200	Firmed	-	8/20/19	10 pcs	0 pcs	10 pcs	\$14.15/pcs	\$141.50
Grand Total:											\$283.00

10 AUG 28 2019 AC

10 AUG 28 2019 AC

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918466

Date: 26-Aug-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 647.4211 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25793 PO: POHB044264 ✓	Rev: N/C	BAS 81 9-89
10 ea	Part: 647.4210 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25794 PO: POHB044264	Rev: N/C	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>AUG 26 2019</u> Certified Signature: <u></u> ✓ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			

RECEIVED

AUG 27 2019

DART AEROSPACE LTD.